CLAIMS

1. A method of casting metal strip comprising:

holding a pair of chilled casting rolls in parallel relationship so as to form a nip between them and such that at least one of the rolls is moveable bodily and laterally relative to the other roll,

continuously biasing said one roll laterally toward the other roll,

setting an initial gap between the rolls at the nip which is less than the thickness of the strip to be cast,

rotating the rolls in mutually opposite directions such that the peripheral surfaces of the rolls travel downwardly at the nip between them,

pouring molten metal into the nip between the rotating rolls so as to form a casting pool of molten metal supported on the rolls above the nip and controlling the speed of rotation of the rolls so as to establish casting of a strip delivered downwardly from the nip which at the outset of casting is produced to a thickness which is greater than the initial gap between the rolls so that the initially formed strip forces said one roll bodily away from the other roll against the continuous bias to increase the gap between the rolls to accommodate the thickness of the initially cast strip, and

continuing casting to produce strip at said thickness and with the gap between the rolls increased beyond the initial gap.

2. A method as claimed in claim 1, wherein the peripheral surfaces of the rolls are negatively crowned when cold by being formed at their midparts to a radius which is less than the radius of end parts of those surfaces, the initial gap being set such that the end parts of the peripheral surfaces of rolls are spaced apart by no more than 1.5mm.

3. A method as claimed in claim 2, wherein the spacing between the end parts of the rolls is in the range

0.5 to 1.4mm.

4. A method as claimed in claim 2 or claim 3, wherein the radial negative crown for each roll is in the range 0.1 to 1.5mm.

5. A method as claimed in any one of the preceding claims, wherein said other roll is held against lateral bodily movement, said one roll is mounted on a pair of moveable roll carriers which allow said one roll to move bodily laterally of the other roll and said one roll is continuously biased laterally toward the other roll by application of biasing forces to the moveable roll carriers.

6. A method as claimed in any one of the preceding claims, wherein the initial gap between the rolls is set by positioning of a stop means to limit bodily movement of said one roll toward the other.

7. A method as claimed in claim 6, wherein the stop means is a stop which is set so as to be engaged by one or both of the moveable roll carriers.